

Work Order ID 57975

April 21, 2010 10:04:50 AM



Page 1

Item ID: D3296-1

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 21/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-4-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3296	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3296 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

2024 .062

1B 10-5-6

(B)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1B 10-5-6

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5.10/05/06

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Work Order ID 57975

April 21, 2010 10:04:50 AM



Page 3

Item ID: D3296-1

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 21/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: ST186

0.00



Packaging

Memo

0.00

Packaging

10/05/10 (13)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/10 AF

10-5-10
(13)

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Picklist Print

April 21, 2010 10:04:55 AM

Page 1

Work Order ID: 57975

Parent Item: D3296-1

Parent Item Name: Door Panel

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:D Now on Waterjet 06-11-02 JLM

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	232.3000	6.9432	9.8		



2024-T3 .063 sheet



B10-5-6

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT22

232.3

111787

2

113866

19.2

113867

19.1

114351

192

114351

13

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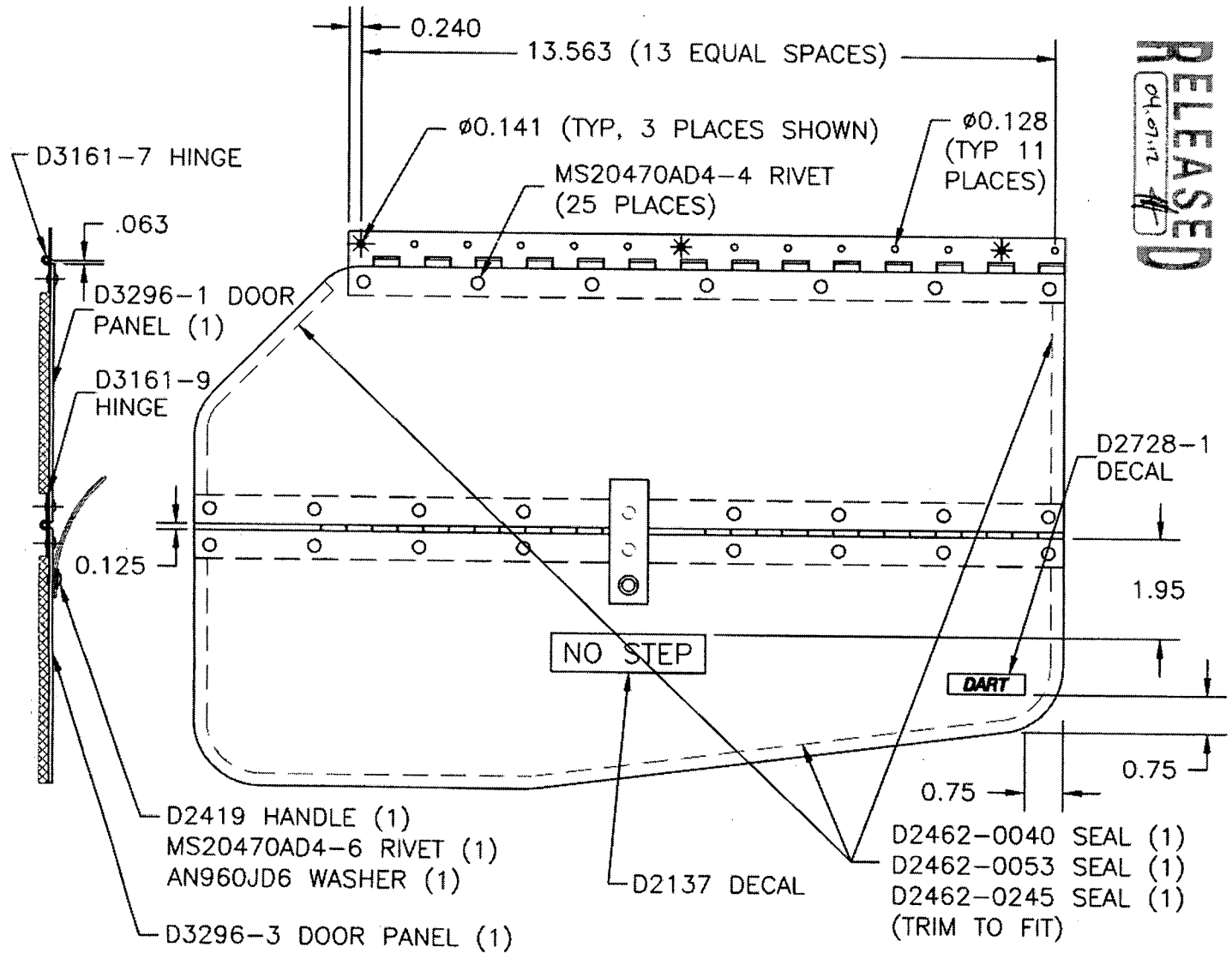
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NO. 52975
0510-424



DESIGN	DRAWN BY	DART AEROSPACE LTD
40	40	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
40	40	D3296
DATE	TITLE	REV. A
04.06.28	DOOR ASSEMBLY	1 OF 2
A	NEW ISSUE	SCALE 1:3

D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

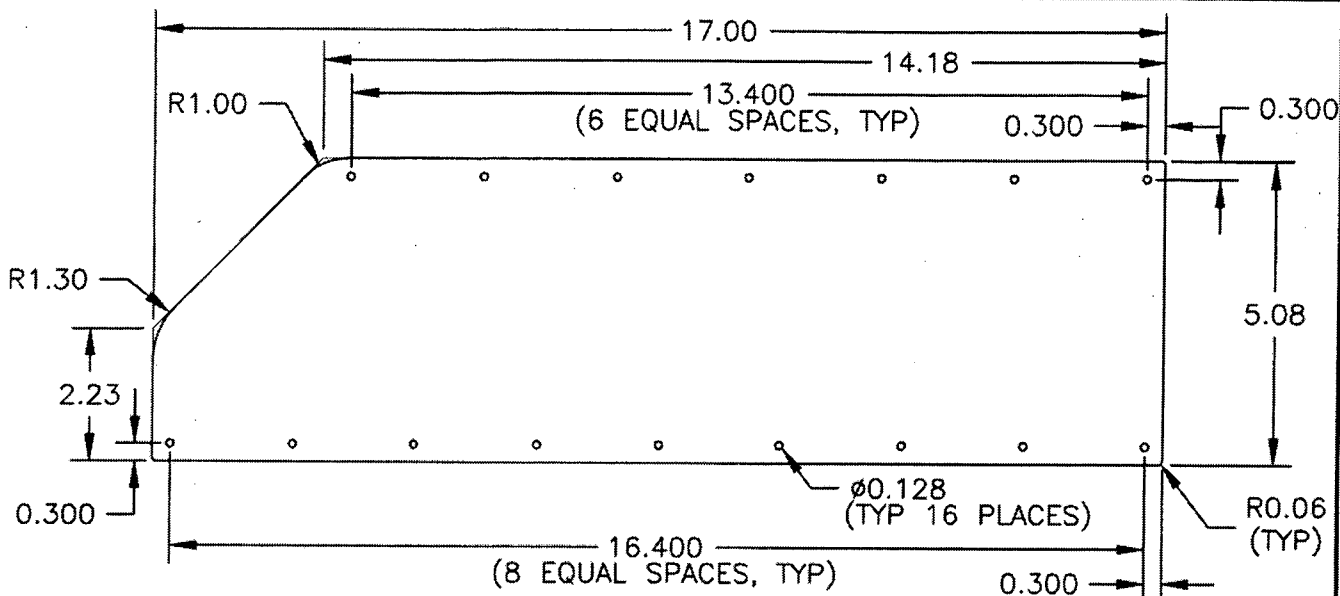
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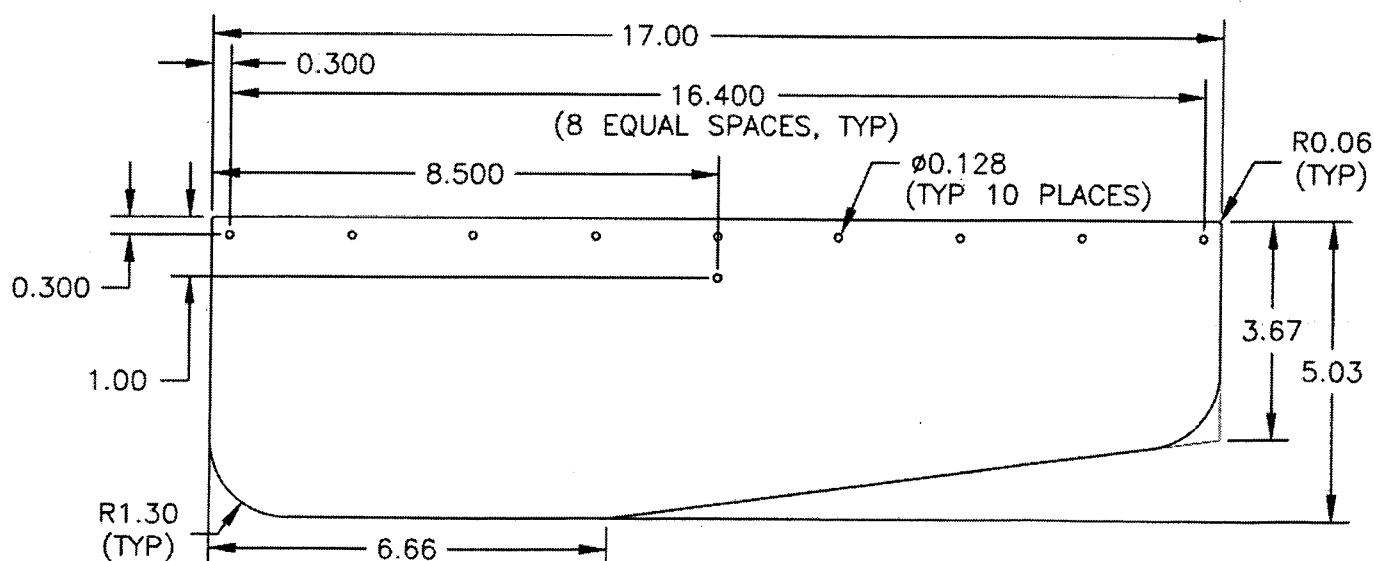


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3

WLO 57975



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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